

Date: Tuesday, 7/4/2006 3:18:26 PM  
 User: Kim Johnston

## Process Sheet

*SLT*

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUBBLE WINDOW, LH	
Job Number	: 27745		Part Number	: D32691	
Estimate Number	: 11393		Drawing Number	: D3269 REV/C/DSI9329 B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 7/4/2006	S.O. No. :	Drawing Revision	: C/B	
Prsht Rev.	: NC		Material	:	
First Issue	: //	Type : PURCHASED PARTS	Due Date	: 7/5/2006	
Previous Run	: 27745		Qty:	10 Um: Each	
Written By	:				
Checked & Approved By	: <i>KJ 06.07.04</i>				
Comment	: Est. A 05.05.22 New issue KJ/JLM Est Rev:B Per Rev C 06-07-03 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>1602</u>	<i>C 207105/06</i>
	Manufacture D3269-1 as per Dwg D3269	(10)
	Possible Supplier: Canus	
	Material release note is required	
2.0	D32691P	Bubble Window, LH R44
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Bubble Window, LH R44	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>P 06/128 (7)</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	<i>Jab 08-01</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	1-Engrave P/N & B/N on lower edge as per Dwg D3269	<i>SB 06/08/08 7</i>
	2-Wrap window in plastic wrap in a clean area.	<i>SB 06/8/21- (6)</i>

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Drawing Name: BUBBLE WINDOW, LH

Job Number: 27745

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP




Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/14	4.0	Window has voids in material causing a bluge in the visual path needed by the pilots.		Return to supplier (Canus) And have them inspect for a root cause of the voids and replace the window, as per NCR 067				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

CANUS PLASTICS INC.  
10 Lisgar Street  
Ottawa, ON  
K2P 0E2

Phone: 613 232 2657      Fax: 613 232 6214  
info@canusplastics.com  
www.canusplastics.com

Packing Slip 127740

CUSTOMER NO. 163233

BILL TO: DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

SHIP TO: SAME

Attn: Accounts Payable

(613)632-3336

DATE	SHIP VIA	F.O.B.	TERMS
07/27/06	CANUS	Our Dock	Net 30 days
P.O. NUMBER	ORDER DATE	SALESPERSON	
PO00001602	07/27/06	TM	
PART NUMBER	DESCRIPTION	QUANTITY	
MFG	D3269-1 LEFT BUBBLE WINDOW	7	7
MFG	D3269-2 RIGHT BUBBLE WINDOW	7	7

# Non-Conformance Report

NCR 067

Raised by:	DARIE TREPANIER	Source:	QC	Sheet No. 1 of 1
Non-Conforming Dept./Supplier:	CANUS	Date:	06.07.04	
Product/Service:	(-1) D3269-2 RH bubble windows	Priority:	HIGH LOW	

Area of Standard:	Section A
QSI	<b>Description of Non-Conformance</b>
QSP	+ CAUSE: <i>Material Received from Supplier</i>
QSPM	<i>is too thin. Windows were made with .125 thick mat'l, Dwg states .188" thick material. All minimum material thickness dimensions are 100% under tolerance. Also 1x D3269-1 (B27745) window has voids in the view area for the pilot, causing a blur.</i>
Documents:	
P/O 1602	
Invoice	
W/O	
Batch No. 27746/45	
TSR	
Drawing D3269 Rev C	

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

**Section B**  
**Corrective Action** Responsible for Investigation/CA: L - L To be done by: 06/08/05.

No	Initial	Action Description	Responsible	Due date	Sign/Date
1.	D.T	Notify Supplier and return have them replace windows to correct material thickness, and ensure they have the proper revision of the Dwg.	J.M.	06/07/04	see NCR 067
2.	D.T	Get corrective from Supplier to ensure this does not happen again	D.L.	06/08/04	14/08/04
3.	J.M.	EMPLOYEE ERROR — EMPLOYEE REPRIMANDED Scrap & destroy 1st set of 3 windows, will be replaced. No charge.	J.M.	06/08/04	See SASUM or original copy
4.	J.M.	Return -1 window to supplier to investigate the cause of the voids in the window			

Preventive Action Required:  YES # \_\_\_\_\_

Fault Category:

Supplier

No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification
1.	Supplier notified of mat'l thickness requirement and of revisions of dwg's.		06/08/04	
2.	Corrective action was employee required			DQA: _____
3.	Windows were destroyed and replaced			Date: _____

QA Purposes only

N/C Closed

Date

DART AEROSPACE  
1270 Aberdeen  
Hawkesbury, ON

N° DE COMMANDE - ORDER NO.	P.O 1602	DÉP. - DEPT.	DATE	06-08-25
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO Tanus Plastics 300 LISCAR Ottawa, ON K2B 0E2			
ADRESSE - ADDRESS	ADRESSE - ADDRESS			
DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
1	D3269-1	B29745		
Window has words in material causing blurred vision				
Please advise if replacement or credit will be issued				
Was this? closed. Yes.				
u				
TPS/GST				
TVP/PST				
274708	SIGNATURE	N° LIC. • LIC. NO.	TOTAL	